

126902

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/01/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 12/03/14 Req'd Qty: 2.00 ***

Customer:

Reference: LeWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3847	C	

0.00

-*170*

HandFinish

Hand Finishing

Memo

0.00

PULL FROM W/O 93939 (WAS CLOSED AND COSTED)

2 X D3847-3 PLATE

APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG

TEXTURE COATING BATCH: 130617

DAS
41
9-89

14-12-1

QC3- Inspect Part Finish

0.00

180

QC

Quality Control

Memo

0.00

DAS
38
9-89

DEC 02 2014

Work Order ID 126902

126902

Page 2

Item ID: D3847-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Fwd Wearplate Assy, Std/ Float Gear
Start Date: 12/01/14 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 12/03/14 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00				42	4	11	14/12/02
190									
Packaging	Memo	0.00							
Packaging	IDENTIFY USING B/N 126902								
200	QC21- Final Inspection - Work Order Release	0.00							14/12/3 JJ
200									
QC	Memo	0.00							
Quality Control									

14-12-02
2

Picklist P

D3847-1 WEARPAD

D3847-043 FWD WEARPLATE ASSY

D3847-045 AFT WEARPLATE ASSY

D3847-047 AFT WEARPLATE ASSY

D3847-049 AFT WEARPLATE ASSY

ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
31	A/R	A/R	A/R	A/R	TEXTURED COATING	SEALANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE

- 7) WEIGHT: D3847-043 = 1.48 lbs
D3847-045 = 1.29 lbs
D3847-047 = 1.70 lbs
D3847-049 = 4.88 lbs

- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9

D3847-11 WEARPAD

RELEASED

2014 NOV 24
ECN 14-628

C	REMOVED D3846-3/-5/-7/-9 GASKETS, ZN D2-1. ADDED TEXTURED COATING, ZN B3-1. UPDATED WEIGHTS, ZN C3-1/A8-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1: 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	D9		
DATE	14.08.06		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D3847
REV. C
SHEET 1 OF 7
TITLE WEARPLATE ASSY
SCALE NTS

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Work Order ID 93939

November-27-12 3:08:18 PM

93939

Page

Item ID: D3847-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 11/22/12 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: MCS Date: 12-11-29 Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3847 B

100

100

Waterjet

FLOW CNC Waterjet

304,050

Memo

1-Cut as per Dwg D3847

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

0.00

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

4

0

Jm 12-12-19

4

0

Jm 12-12-19

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93939

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 11/22/12 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 12/07/12 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Brake NC

Memo

0.00

Brake NC

form as per dwg D3847

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Work Order ID 93939

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93939

Page 4

Item ID: D3847-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 11/22/12 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC5- Inspect part completeness to step on W/O	0.00							
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180

QC	Memo	0.00							
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Quality Control

190	Identify as per dwg & Stock Location:	0.00							
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190

Packaging	Memo	0.00							
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Packaging

200	QC21- Final Inspection - Work Order Release	0.00							
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200

QC	Memo	0.00							
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Quality Control



DART AEROSPACE LTD		Work Order:	93939
Description: Plate		Part Number:	D3847-3
Inspection Dwg: D3847	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.192"	-		✓	Jkmo1
0.300	+/-0.010	0.305"	-		✓	
0.300	+/-0.010	0.304"	-		✓	
3.280	+/-0.010	3.280"	-		✓	
2.45	+/-0.030	2.461"	-		✓	
4.13	+/-0.030	4.134"	-		✓	
1.69	+/-0.030	1.691"	-		✓	
0.75	+/-0.030	0.758"	-		✓	
6.88	+/-0.030	6.877"	-		✓	
10.000	+/-0.010	10.004"	-		✓	Praewer
18.000	+/-0.010	18.000"	-		T	Jkmo6
39.53	+/-0.030	39.53"	-		T	
14.484	+/-0.010	14.484"	-		T	
28.967	+/-0.010	28.967"	-		T	
32.467	+/-0.010	32.467"	-		T	
33.967	+/-0.010	33.967"	-		T	
37.467	+/-0.010	37.467"	-		T	
0.050	+/-0.010	0.047"	-		✓	

Measured by:	Jm
Date:	12-12-19

Audited by:	DAS
Date:	12-12-20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue P/O D3847-043	KJ	

Picklist Print

November-27-12 3:08:17 PM

Page 1

Work Order ID: 93939

Parent Item: D3847-043

Parent Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 11/22/12

Required Date: 12/07/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3846-3 GASKET		Manufactured	No				Each	2.0000		4			

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP002	2	
	89605	2	
M304S18GA 304/316 .050 Sheet	Purchased	No	sf 54.2649

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	54.264947	
120243	2.5	
121626	1.65	
121660	11.000737	
123155	36.66421	
123372	2.45	

124029

2

4.5473684

4.6

Jan 12-12-19

124029

